



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D2435
Job Sheet 169648



Part No: D2435

Job Qty: 6 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/18/17

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV E1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/11/18	0.00	0.00	Start Up Container		SC
120	Waterjet	6 pcs		1/11/18	0.00	1.12	Waterjet1		SC
130	CNC Vertical Machining	6 pcs		1/12/18	0.41	6.09	HAAS 1		mgnl 18/01/19
150	QC	6 pcs		1/12/18	0.00	0.00	QC8		18/01/20
151	Packaging	6 pcs		1/12/18	0.00	0.00	Packaging3 ST 446 A		AT 18/01/21
190	QC21-SA	6 Ea		1/12/18	0.00	0.00	QC21		21 18/01/21

Part Op 120 - CUT BLANK AS PER FILE D2435

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

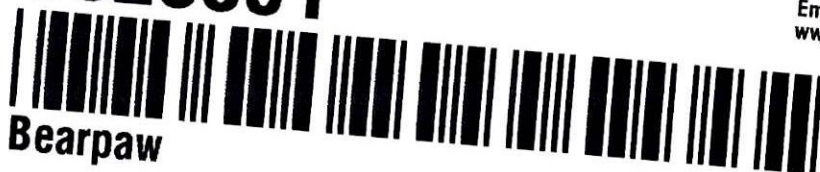
Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10 M138608	19	1,009	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053		
2	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	Angle	
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470		
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170		
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius	
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220		
7	Bearpaw	0.625Inches ± 0.030	0.655 0.595		
8	Bearpaw	0.250Inches ± 0.010	0.260 0.240		
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	Angle	

DART
AEROSPACE
S025801



Bearpaw

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PART NO:
Revision:
Operation:
Change No:

D2435

Start up Operation

Mfg Date: 12/20/17
Job No: 169648

10	Bearpaw	0.375Inches ± 0.010	0.385 0.365	
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970	
12	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940	
13	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	Diameter
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	Diameter
15	Bearpaw	0.300Inches + 0.030 - 0.000	0.330 0.300	
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345	
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345	
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240	
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970	
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990	
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720	

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